

Date: Monday, 02/06/2008 4:32:17 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MIRROR BRACKET		
Job Number	: 39636A			Part Number	: D2161204		
Estimate Number	: 10142			Drawing Number	: D2161 REV B2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/06/2008 S.O. No. :			Drawing Revision	: B2		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 10/06/2008 Qty: 5 Um: Each		
Previous Run	: 36919						
Written By	:						
Checked & Approved By	: <u>JUL 08-6-02</u>						
Comment	: Est Rev:A New Issue 05-11-01 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	39636A01	MIRROR BRACKET	
2.0	39636A02	MIRROR BRACKET	
3.0	39636A03	ARM	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	X5
5.0	-DO NOT USE-	WELD INSPECTION	P70

Comment: Sub-Component MIRROR BRACKET
D2013-5 B B 39636A01 ✓ *LPC 09-02-11*

Comment: Sub-Component MIRROR BRACKET
D2013-6 B B 39636A02 ✓ *LPC 09-02-11*

Comment: Sub-Component ARM
D2037-101 B 41854 → 1 ✓ 341316A03 → 4 ✓ *LPC 09-02-11*

1-Assemble on Jig DT8065 as per Dwg D2161
LPC 09-02-11

2-Weld as per Dwg D2161 Identify as D2161-204
LPC 09-02-11

Comment: WELD INSPECTION
5.1 QL5 *for 09-12 (5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.02.11	S.O	After Sequence 4.0 there should be a QA check. Please change. Perm. Change	HJ	09.02.10		09.02.12	09.02.12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MIRROR BRACKET

Job Number: 39636A

Part Number: D2161204

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M105642



(5X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10-10
320 OF

OVEN TEMPERATURE:

320

FINISH TIME:

10-40

M-F 09/02/14

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PPA 45877



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mt
09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

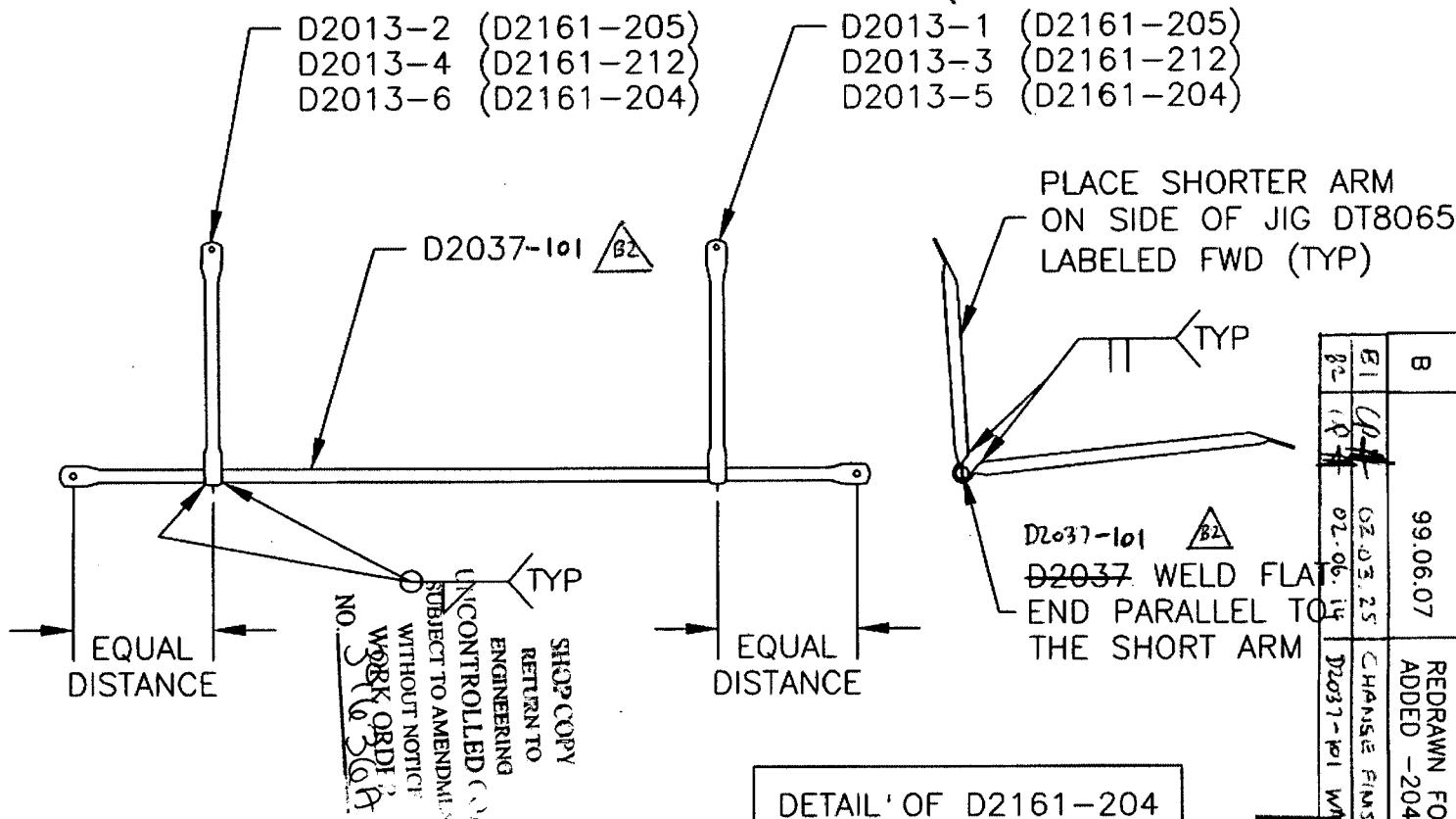
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED	DRAWING NO. D2161
DATE 99.06.07	CHANGED 02.03.25	REV. B SHEET 1 OF 1
A	93.04.29	SCALE MTS



FINISH: POWDER COAT ASSEMBLY BLACK
CRINKLE (4.3.5.3) PER DART QSI 005 4.3
POWDER COAT BLACK SANTEX (4.3.5.7) PER
DART QSI 005 4.3 *13A*

RELEASED
KE 99.06.10